



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2857-2
Job Sheet 188524



Part No: D2857-2

Job Qty: 20 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 1/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D 06.03.30

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		1/24/19	0.00	3.47	Bandsaw - 1		SB L 19/02/07
110	HAAS 4 Axis - B4B	20 pcs		1/24/19	0.18	9.62	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SB L 19/02/08
							HAAS - 4 - B4B		
130	QC 8	20 pcs		1/24/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		smk 19/02/08
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
140	Handfinish - 1-1 Chemical-B4B	20 pcs		1/24/19	0.00	0.39	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		



Container No: S151803



Part: D2857-2

Job No: 188524

Serial No/Batch: S151803

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 02/07/19

					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	DR 19/2/11
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					2Handfinish - 1 - 22 - B4B	
150 QC 3	20 pcs	1/24/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34	BL 19-02-12	
				QC 3 - 36		
				QC 3 - 38		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		
160 Powdercoat - 1 White Gl(A) -B4B M138997	20 pcs	1/24/19	0.00 0.27	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B	BL 19-02-12	
				Powdercoat - 4 - B4B		
170 QC 3	20 pcs	1/24/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 38		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		

START 2:15 O/T:300 FINISH 2:45.

DR
40
9/88

DR
40
9/88

19/02/22

180 Packaging 3-1 - Stock - B4B	20 pcs	1/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	Stop SA FEB 22 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190 QC 21 - SA	20 pcs	1/24/19	0.00 0.00	QC 21 - SA - 21	DAG 21 FEB 22 2019
				QC 21 - SA - 70	9-08

Part Op 100 - (Bandsaw) Cut blanks 4.425"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 FOLIO REV: A4
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC3- Inspect Part Finish)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25	7.4000 ft (.37 ea)	100-Bandsaw - 1	52 79 79

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X01.250	7	30	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches ± 0.010	4.310 4.290	4.299	4.294
2	Hinge Bracket	4.000inches ± 0.010	4.010	4.000	

MAT
used
6.057'

SCRAP
0.208'

			3.990		
3	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	,340	
4	Hinge Bracket	1.110inches ± 0.005	1.115 1.105	,110	
5	Hinge Bracket	1.790inches ± 0.010	1.800 1.780	,790	
6	Hinge Bracket	1.320inches ± 0.005	1.325 1.315	,320	
7	Hinge Bracket	2.000inches ± 0.010	2.010 1.990	,2000	
8	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	,340	
9	Hinge Bracket	0.447inches ± 0.010	0.457 0.437	,446	
10	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171	,171	
11	Hinge Bracket	0.147inches ± 0.010	0.157 0.137	,145	
12	Hinge Bracket	0.376inches ± 0.010	0.386 0.366	,378	
13	Hinge Bracket	0.126inches ± 0.010	0.136 0.116	,123	
14	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	,06	
15	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	,166	
16	Hinge Bracket	0.911inches ± 0.010	0.921 0.901	,911	
17	Hinge Bracket	0.600inches ± 0.010	0.610 0.590	,600	
18	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	,125	
19	Hinge Bracket	0.150inches ± 0.010	0.160 0.140	,150	

Plex 1/10/19 12:46 PM Dart.lajeunesse.marie